

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009671**Date Inspected:** 20-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

**Bay #11 East and West Tower Shop**

East Tower Lift #3:- Caltrans QA Inspector observed five ZPMC grinders and one welder in process of grinding and FCAW repair welding on fit lugs of interior diaphragms. The fit lugs located at the elevation 85.25m to 111.67m diaphragm sections that connected skin plate D of east tower lift #3. The grinding and FCAW repair welding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift #3:- Caltrans QA Inspector observed four welders performed FCAW process on inner corner longitudinal seam weld that connected skin plate A to E and C to D. The FCAW welding located at elevation 89m, 95.5m 102.5m and 105.5m diaphragm section. The FCAW welding were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

West Tower Lift #3:- Caltrans QA Inspector observed six ZPMC grinders and one welder in process of grinding and FCAW repair welding on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 85.25 m to 111.67m diaphragm sections that connected skin plate A and E of west tower lift #3. The grinding and FCAW repair welding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

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# WELDING INSPECTION REPORT

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West Tower Lift #2: - The west tower lift #2 has been removed to milling area for machining after lunch today.

## Tower Assemble Yard

East Tower Lift #1:- Caltrans QA Inspector observed ZPMC four grinders performed grinding process on buildup weld metal for weld joint bevel. The buildup weld metal is on stiffeners which located at exterior bottom tower of skin plate B, C and D for east tower lift #1. The grinding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted. Based on Caltrans QA inspector observations, no discrepancies were noted

East Tower Lift #1 & #2:- Caltrans QA Inspector observed six ZPMC workers installed two corner spite plates which connect to skin plate B to C and C to D. The alignments of two corner spite plates have been accepted by ZPMC and ABF. Two spite plates will start drilling the hole tomorrow. Caltrans QA Inspector observed four ZPMC workers installed inner spite plate on the outside tower skin plate C. The purpose of installion is for mark up the drill holes location on the spite plate.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

As notes within report above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinoved 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau, Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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